

Date: Wednesday, 3/7/2007 4:26:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD DOOR LH		
Job Number	: 31078C01		Part Number	: D31861M		
Estimate Number	: 12598		Drawing Number	: D3186 REV.D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/7/2007	S.O. No. :	Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: 3/7/2007	Type :	Due Date	: 3/30/2007	Qty:	1
Previous Run	: 31047C01		Um:	Each		
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: _____ Description: D3186-1M Door Supplier: Delastek Conformity Certificate and Process sheet required		
2.0	D31861P	Spacepod Door
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Spacepod Door		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of door is smooth, no dimples for drilling.		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:26:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31078C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

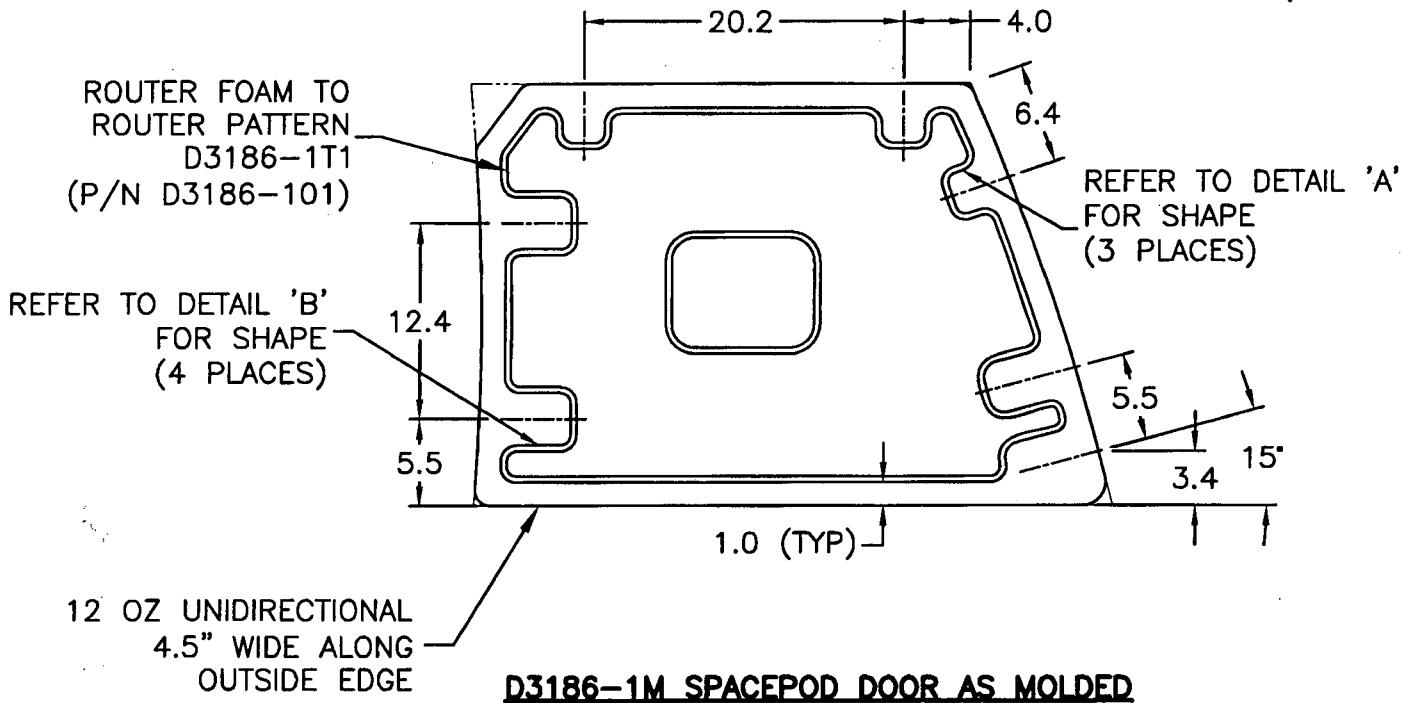
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>SH</i>	DRAWING NO. D3186 REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR SCALE NTS
A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

RELEASED07.02.27 *SH*NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL SHOP COPY
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL") RETURN TO ENGINEERING
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 31078C01

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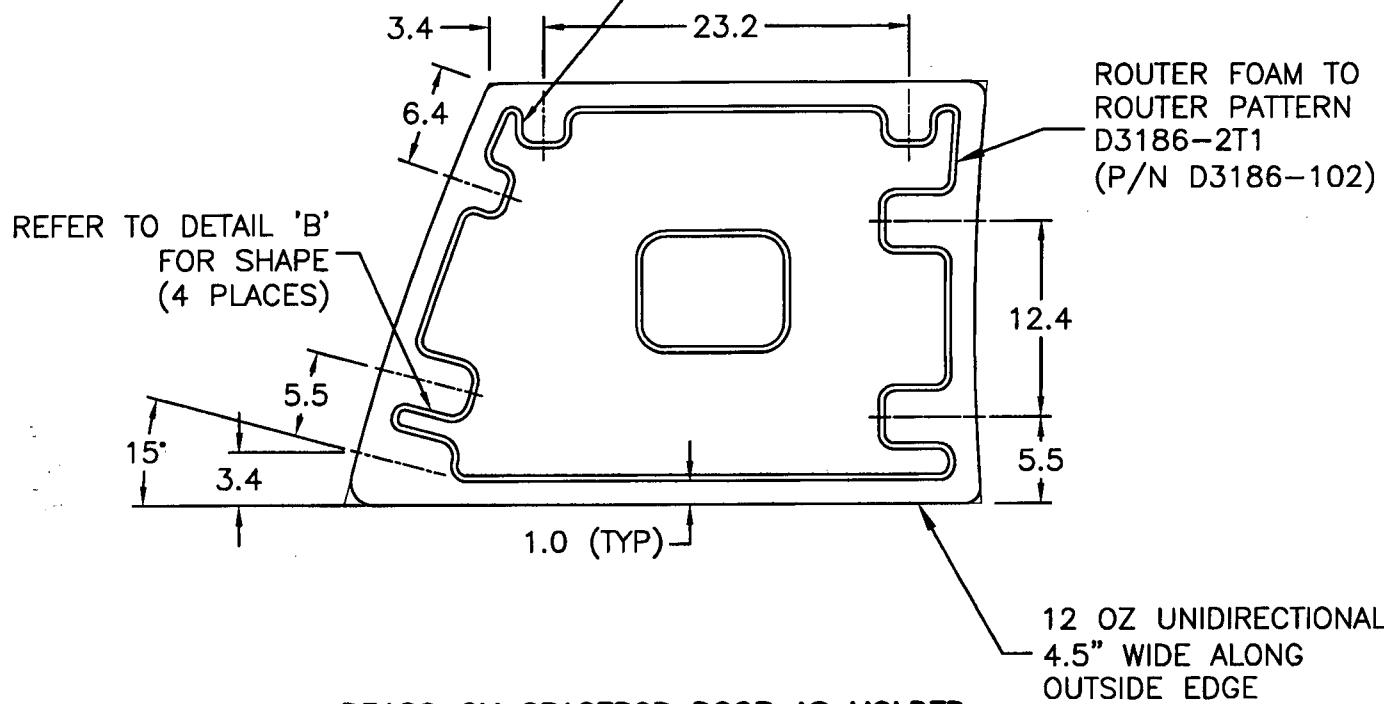
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CHECKED <i>BS</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

RELEASED07.02.27 *CH*

REFER TO DETAIL 'A'
 FOR SHAPE
 (3 PLACES)

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
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DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BS</i>	APPROVED <i>JK</i>	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

20.25 4.70

1.80

5.50

D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

RELEASED

07.02.27 *JK*

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

5.50

3.46

15°

0.98 (TYP)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

3.59 1.80

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)

12.45

5.50

0.98 (TYP)

D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

2.78

1.24

19°

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NOTES:

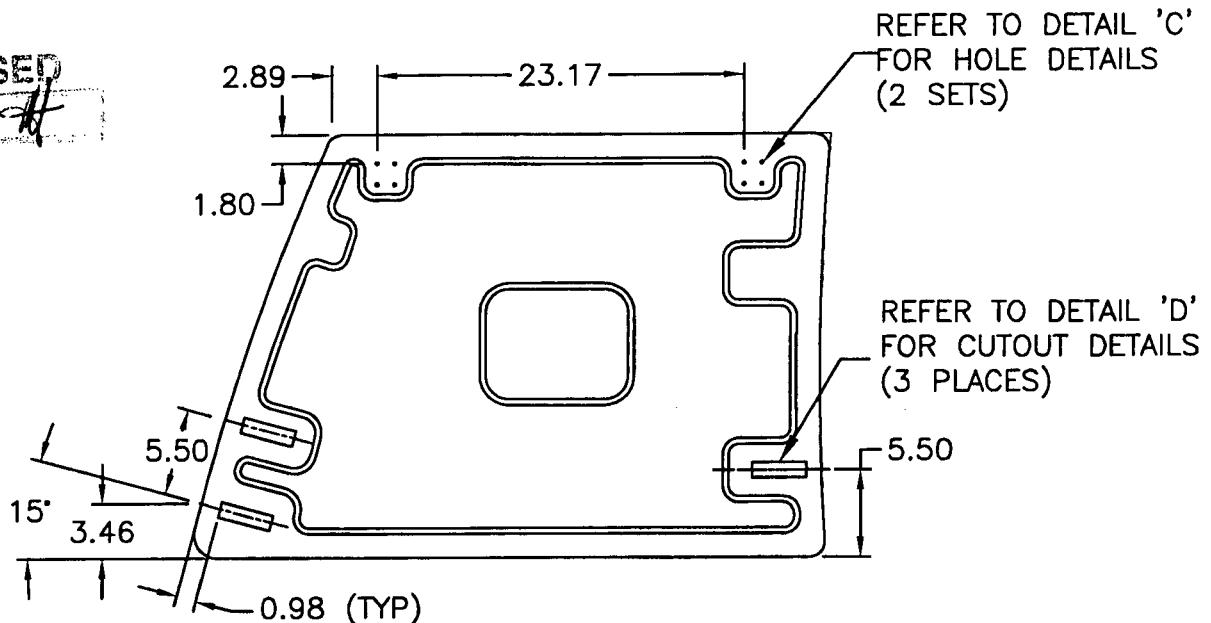
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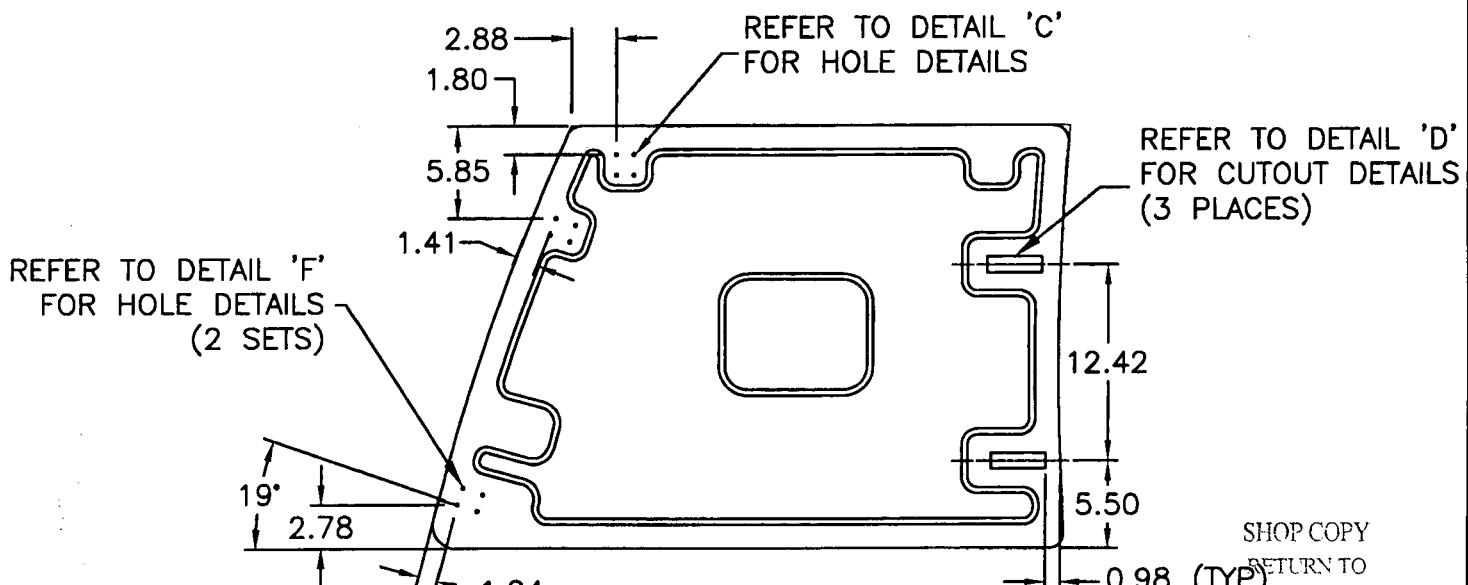
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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.22	TITLE	SHEET 4 OF 5 SPACEPOD DOOR NTS

RELEASED07-02-27 *CE*

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

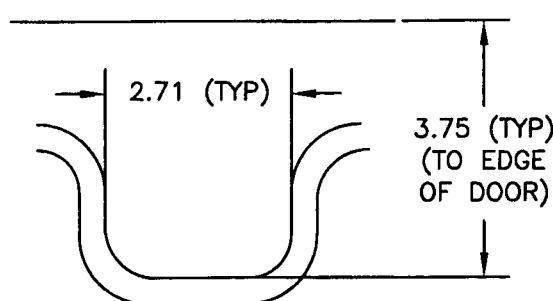
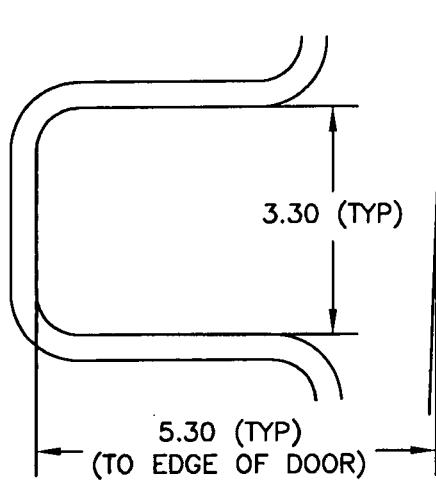
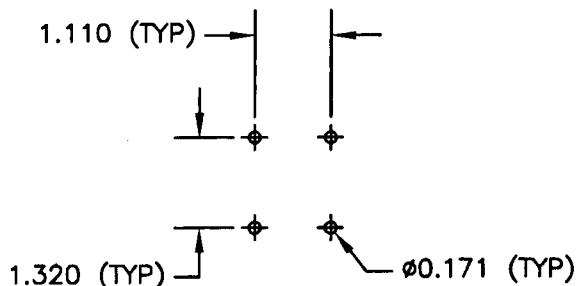
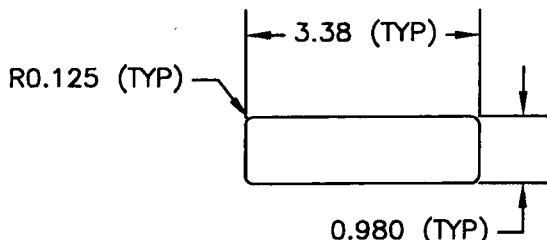
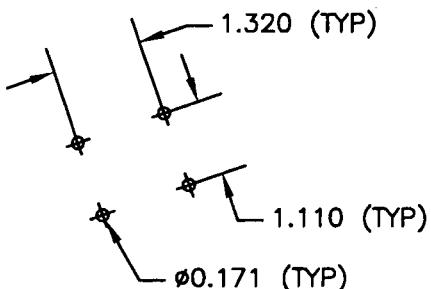
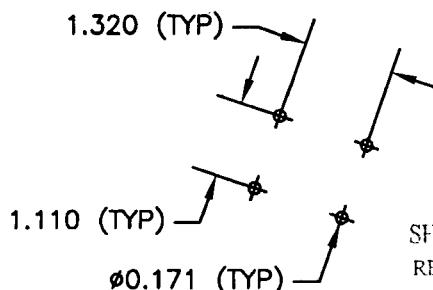
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CHECKED <i>BS</i>	APPROVED <i>CH</i>	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****RELEASED**07.02.27 *CH***DETAIL C**NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR**DETAIL D****DETAIL E****DETAIL F**
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W/H CUT NOTICE

WORK ORDER
NO. 31078C01**NOTES:**

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